Date:

Tuesday, 12/5/2006 8:13:14 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number **Estimate Number** : 29766 : 12538

P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

:N/M

: 12/5/2006

: NC

: 11

: SMALL /MED FAB Type

: 29653

Written By

Checked & Approved By Comment

: Est Rev:A

New Issue 06-09-27

Drawing Revision Material

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: 12/23/2006

: BRACKET

: D35461

: N/A

D3546 REV A

Qty:

40 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M304S18GA

304/316 .050 Sheet

Comment: Qty.: 0.2205 sf(s)/Unit Total: 304 SS SHEET 18GA

Batch: M 100c1

8.8200 sf(s)

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev:__A

Prog Rev: A

8 12 11

2-Deburr if necessary

QC2 3.0

INSPECT PARTS AS THEY COME OFF MACHINE



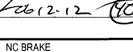
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

Comment: SECOND CHECK

BRAKE NC 5.0



SECOND CHECK



Comment: NC BRAKE

Form as per Dwg D3546



10/01/03

Dart	Aer	ao'	oace	Ltd

W/O:		WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			QA: N/C	Closed:	Date:	
Part No:	PAR #:	Fault Category:	NCR: Yes (Nd	DQA:	Date: 07/01/	0

NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Varification	Annanal	Ι
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:13:14 AM Kim Johnston User: **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 29766 Part Number: D35461 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 7.0 POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE # Comment: PACKAGING RESOURCE #1 Identify and Stock Location:__ QC21 10.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHAI	NGES
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes No DQA: Date:

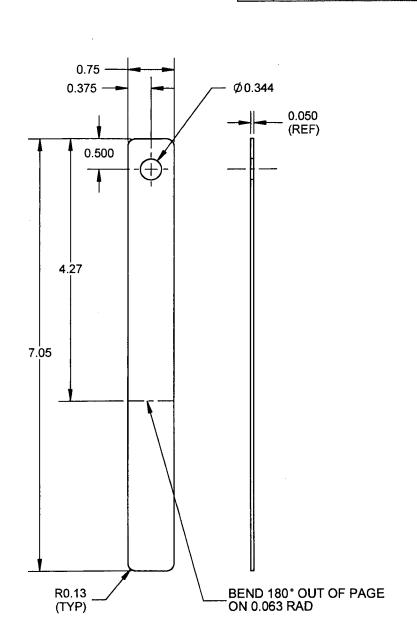
QA: N/C Closed: ____ Date: __

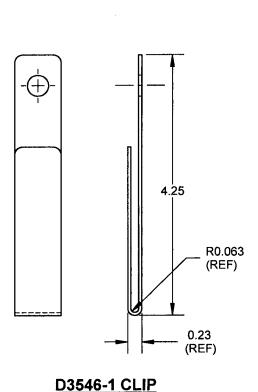
NCR:	CR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		V-uf-ation A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

DESIGN		DRAWN BY	DART AERC HAWKESBURY, O	
CHECK	ED (7	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
DATE	06.0	9.15	TITLE	SCALE 1:1
REV		DATE	DESCR	RIPTION

06.09.15 NEW ISSUE Α





D3546-1F FLAT PATTERN

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE.

NOTES: 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES TO 0.010 MAX

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DART AEROSPACE LTD		Work Order:	29766
Description: Brachet	3 2	Part Number:	03546-1
Inspection Dwg: D 3546 Rev	v: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST X First Article X Prototype

N Flist Viticie V Liotothe									
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
7.05	+1-0.030	7.05	1 -		VerN				
0.375	+1-0.010	0.374	V -		VECN				
0.75	41-0.030	0.752	1 -		VerN				
0.344	H-0.006,0.001	0.345	/ -		VERN				
0.050	1-0010	0.046	1.1 -	-	Vern				
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Measured by: mi: mi	Audited by:	Prototype Approval:	NIA
Date: 06 12 11	Date: 06:12-12	Date:	

Rev	Date	Change		Revised by	Approved
Α		New Issue	: .	KJ/JLM	